

Work Order ID 133603 - 2

Thursday, June 11, 2015 11:31:39 AM

SPLIT

133603

Page 1

Item ID: D3883-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Outboard RH

Start Date: 6/11/15 Start Qty: 5.00

5 4
5

Cust Item ID:

Required Date: 6/19/15 Req'd Qty: 5.00

Customer:

Reference: REWORK AS PER ECN 15-575

Approvals: Process Plan: 

Date: 156-11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3883	D

130	Chemical Conversion Coat per QSI005 4.1	0.00
-----	---	------

130

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK
D3883-2 X5
B:129065

REMOVE PAINT INSIDE SADDLE AS PER ECN 15-575

5  15-6-10

Split-1

150	QC3- Inspect Part Finish	0.00
-----	--------------------------	------

150

QC

Memo

0.00

Quality Control

4  15-6-24

DAS
41
9-89

15-6-24

DQA:

Date: 15/06/30



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/06/30

Work Order update only ☐

Work Order: <u>133603</u> Part No. <u>03883-2</u> NCR No. <u>15-5159</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☒</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																																																																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																																																				
Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐																																																																																																																																				
Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																																					
Date: <u>15/06/22</u>		Step #: <u>#100</u>		QTY Effective: <u>x 5</u>		MRB (QSI042) Approval <u>15/06/22</u>																																																																																																																																	
Description Work Order Deviation Due to Applying "Part strain" some of the Powder Coat has been removed from the outer surface. 2C. Design change; Manufacture Processes				Disposition Acceptable to touch up Powder Coat as per Q52005 1. Clean Area Thoroughly 2. Apply "inner Part" as per Q52005 3. Gently wet sand to remove any high spots 4. Repeat steps # 2 and 3 if necessary				Complete By <u>41</u> <u>15-06-24</u> Lead hand / Supervisor Approval Verification <u>DAS</u> <u>38</u> <u>9-89</u> <u>11/11/25 2015</u>																																																																																																																															
				QA/CA Coordinator <u>9</u> Approval <u>8-89</u> <u>15-06-25</u>																																																																																																																																			
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☒</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☒	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table style="width:100%;"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☒</td><td>Finish</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>				Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☒	Finish	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Environment	☐	No Re-verification	☐																																																																																																																																				
Design	☐	Operator	☐																																																																																																																																				
Doc/Data	☐	Offset/Setup	☐																																																																																																																																				
Equip/Tooling	☐	Supplier	☐																																																																																																																																				
Handling/Pre	☐	Training	☐																																																																																																																																				
Material	☐	Use for Testing	☐																																																																																																																																				
Internal Transport	☐	Poor Information	☐																																																																																																																																				
Tribal Knowledge	☐	Rushing	☐																																																																																																																																				
LOA	☐	Product Improvement	☐																																																																																																																																				
Substation	☐	Process Improvement	☐																																																																																																																																				
Past Expiry Date	☒	Manufacturing Process	☐																																																																																																																																				
Misidentified	☐	Past Due	☐																																																																																																																																				
Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																																
Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐																																																																																																																																
Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐																																																																																																																																
Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐																																																																																																																																
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																
Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐																																																																																																																																
Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐																																																																																																																																
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☒	Finish	☐																																																																																																																																
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐																																																																																																																																
Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																
OTHER :																																																																																																																																							

Work Order ID 133603

133603

Page 2

Thursday, June 11, 2015 11:31:39 AM

Item ID: D3883-2 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Saddle, Outboard RH

Start Date: 6/11/15 Start Qty: 5.00 *5* Cust Item ID:

Required Date: 6/19/15 Req'd Qty: 5.00 *5* Customer:

Reference: REWORK AS PER ECN 15-575

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST404</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging	PUT BACK INTO STOCK UNDER NEW BATCH NUMBER								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

CL 15/06/26 4

MLJ JUN 29 2015

MLJ JUN 29 2015

Picklist Print

Thursday, June 11, 2015 11:31:44 AM

Page 1

Work Order ID: 133603

133603

Parent Item: D3883-2

D3883-2

Parent Item Name: Saddle, Outboard RH

Start Date: 6/11/15

Required Date: 6/19/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3883-2		Manufactured	No				Each	2.0000		5			
---------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D3883-2

**

Saddle, Outboard RH

Location

Loc Qty

Loc Code

ST404

2

129065

2

5 (Handwritten signature) 15-6-11